

ASAP PLEASE

Dart Aerospace Ltd.

Date: Tuesday, 13/02/2007 9:16:59 AM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 30731		Part Number	: D33193	
Estimate Number	: 10606		Drawing Number	: D3319 REV. B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 13/02/2007		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 19/02/2007	
Previous Run	: 29636		Qty:	6 Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est: N/A 05.05.12 New issue KJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM				

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048 .052 as per Peter 07-02-14	
		Comment: Qty.: 3.4150 sf(s)/Unit Total : 20.4901 sf(s) 1010/1025/A21/6aA SHEET .048" Thick Batch: M101034 ml 07 02 14	(6)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B Prog Rev: B	(6)
		ml 07 02 14	
		2-Deburr if necessary	
3.0	QC2	AS Rev template ml 07 02 14	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	(6)
4.0	QC8	SECOND CHECK J070214 (6)	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 J070214 (6)	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary	
		J070214 (6)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/02/2007 9:16:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30731

Part Number: D33193

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

873 07/02/19(6)

7.0 QC6 DIMENSIONAL CHECK



*20702-16(6)*



Comment: DIMENSIONAL CHECK

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	M103031

FC 07 02 19(6)

9.0 QC9 VISUAL WELDING INSPECTION



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/02/19(6)

10.0 POWDER COATING POWDER COATING



*m101601*

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*Ex/Am*

07/02/20(6)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FC*

07/02/20(6)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: \_\_\_\_\_

*671121(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/02/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/02/2007 9:16:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30731

Part Number: D33193

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



(6)

Comment: FINAL INSPECTION/W/O RELEASE

13/02/2007

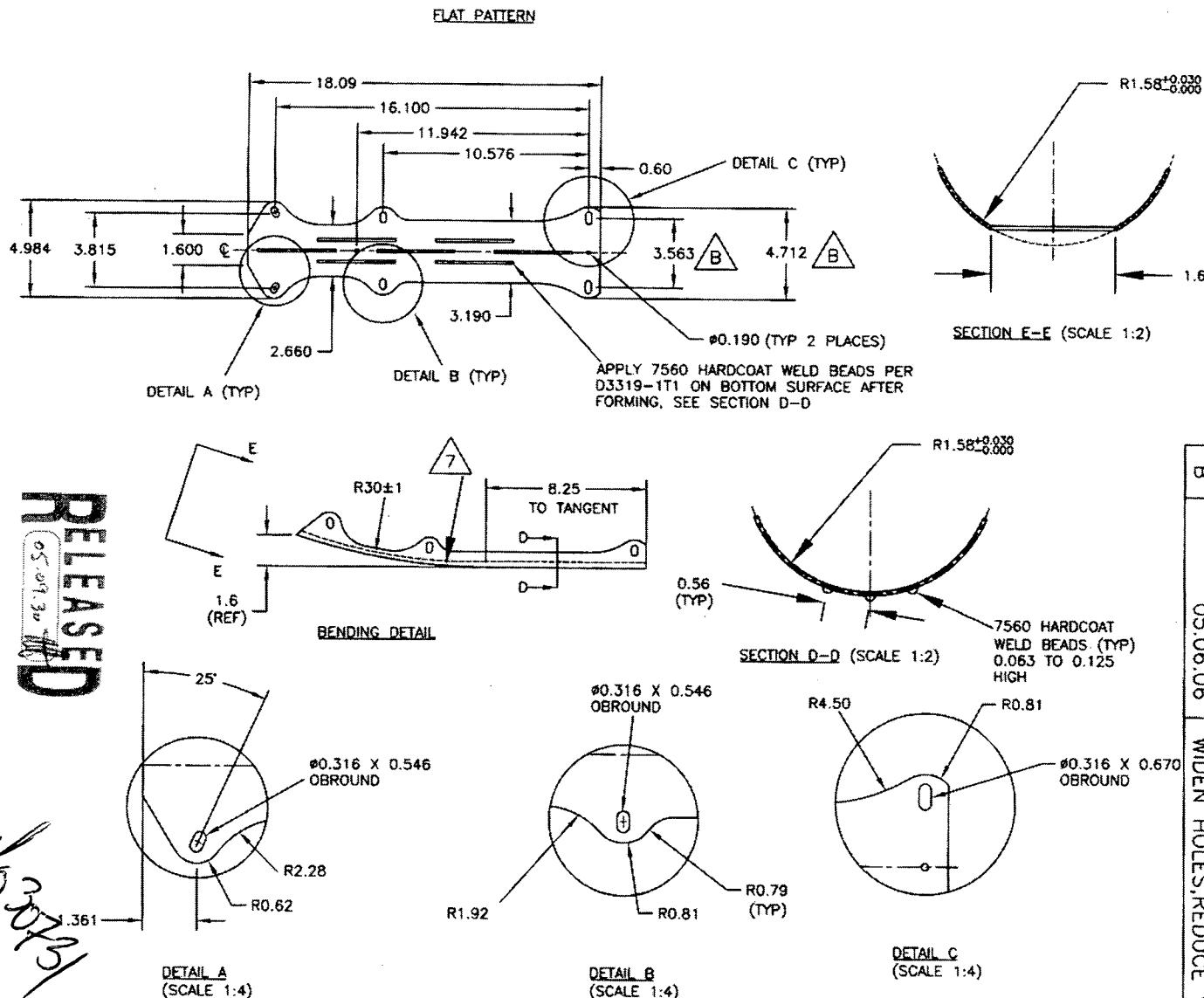
Job Completion



(207/02/21)



DESIGN P1	DRAWN BY P1	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	REV. B
DATE 05.06.06	TITLE WEARPLATE	HAWKESBURY, ONTARIO, CANADA	
SCALE 1:8	SCALE 1:8	SHEET 1 OF 5	REV. B
A	04.09.24	NEW ISSUE	
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	

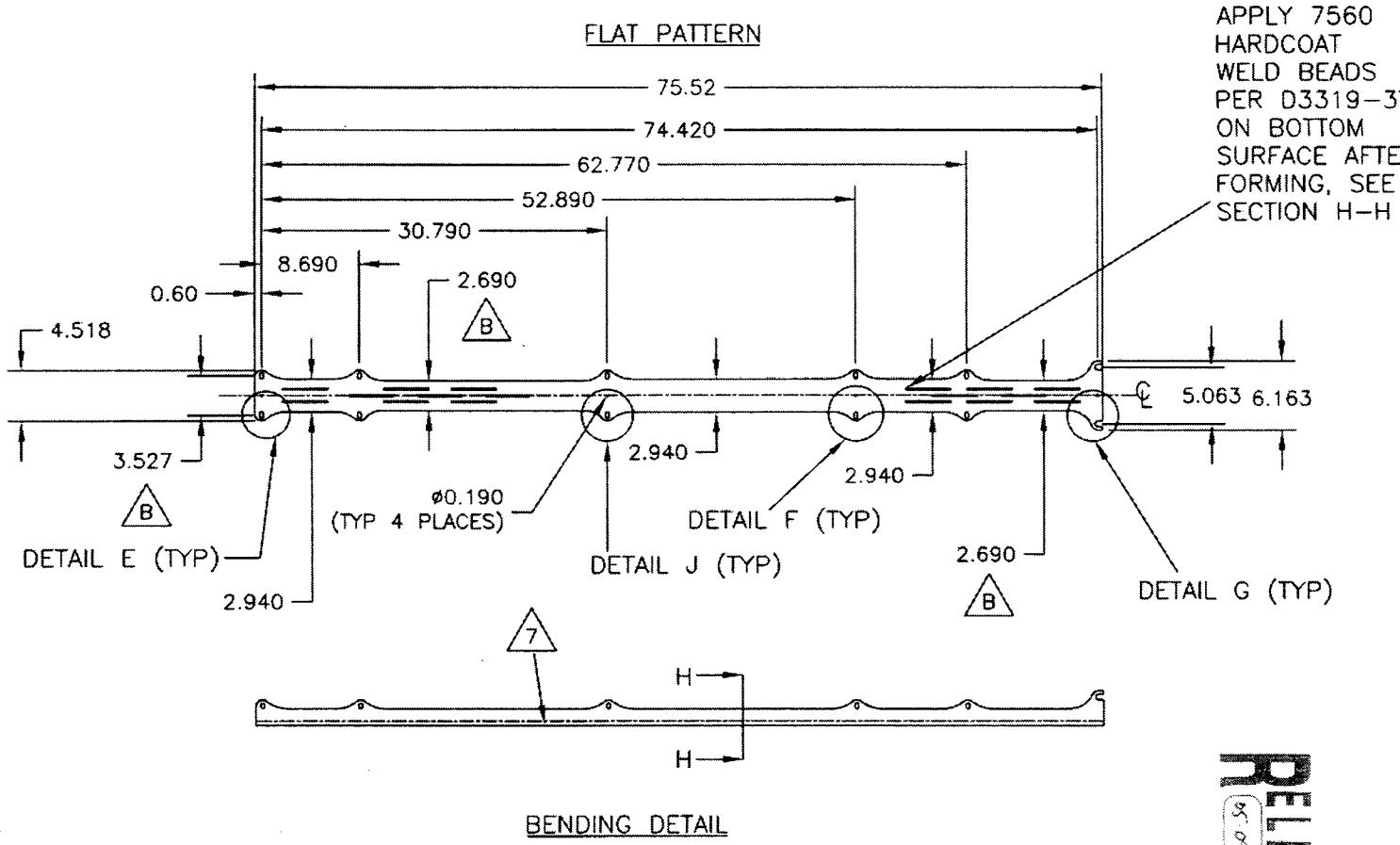


**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**RELEASED**  
05.09.30 *[Signature]*

*[Signature]*

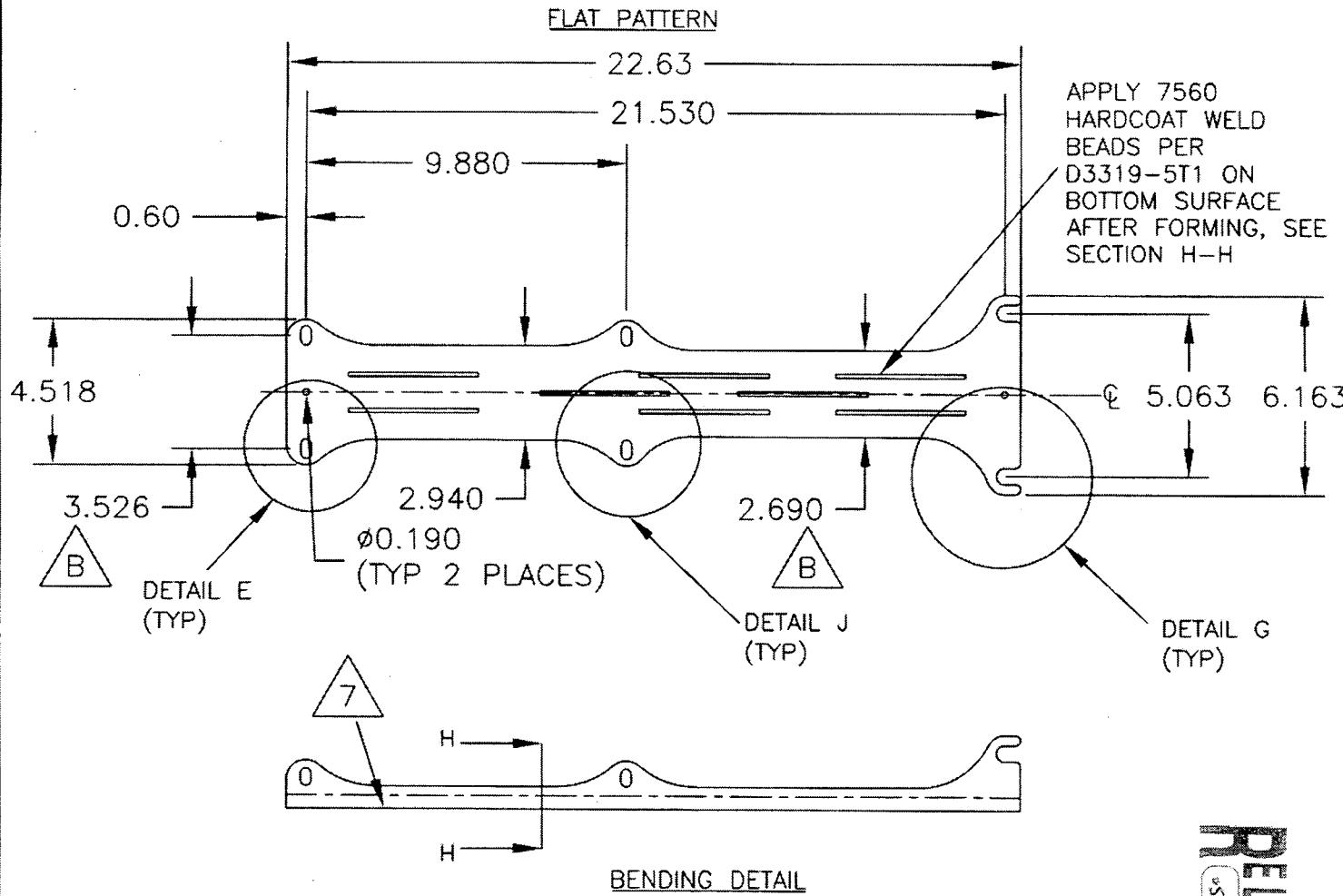


RELEASED  
05/01/34

DESIGN P4	DRAWN BY P4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3319
DATE 05.06.06		SCALE 1:15

#### D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

DESIGN P4	DRAWN BY P4	DART AEROSPACE LTD	
CHECKED H	APPROVED H	DRAWING NO. D3319	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06	TITLE WEARPLATE	REV. B	SHEET 3 OF 5
SCALE 1:5			

**RELEASED**  
05-09-347

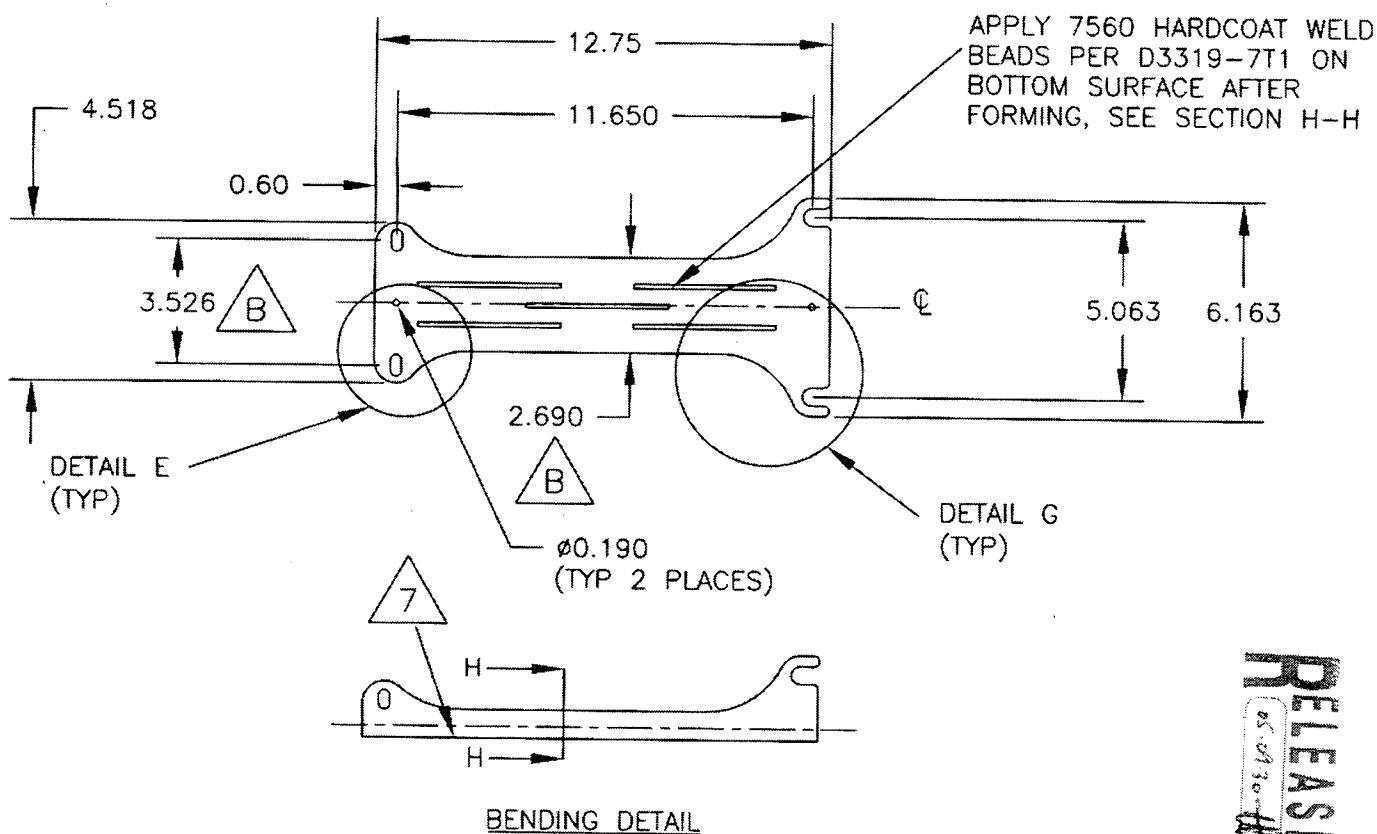


**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN PH	DRAWN BY B4	APPROVED H	DRAWING NO. D3319	REV. B	SHEET 4 OF 5	SCALE 1:5
DATE 05.06.06			TITLE WEARPLATE			

**RELEASED**  
05.06.06

FLAT PATTERN

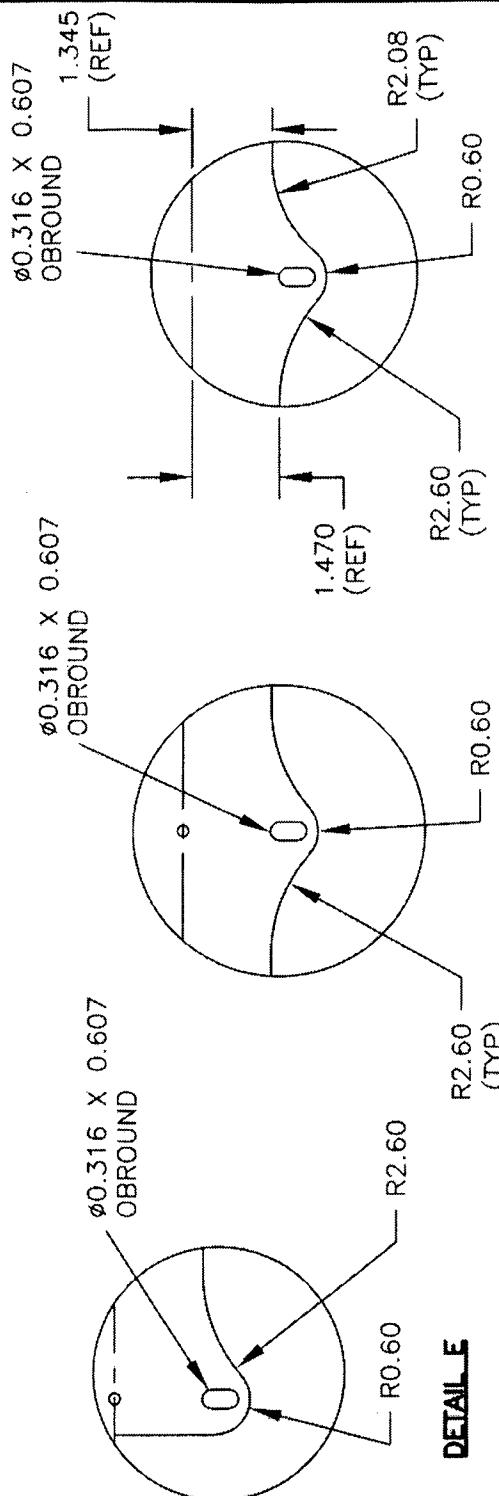
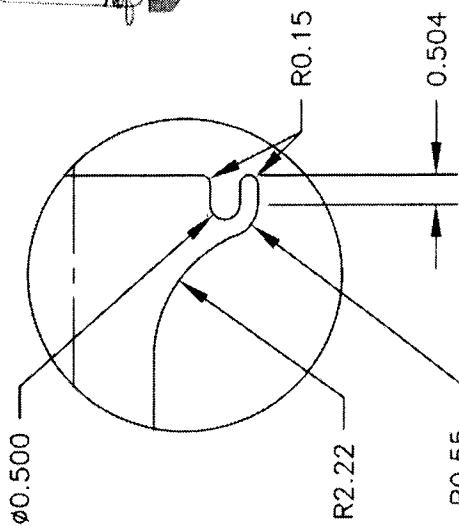
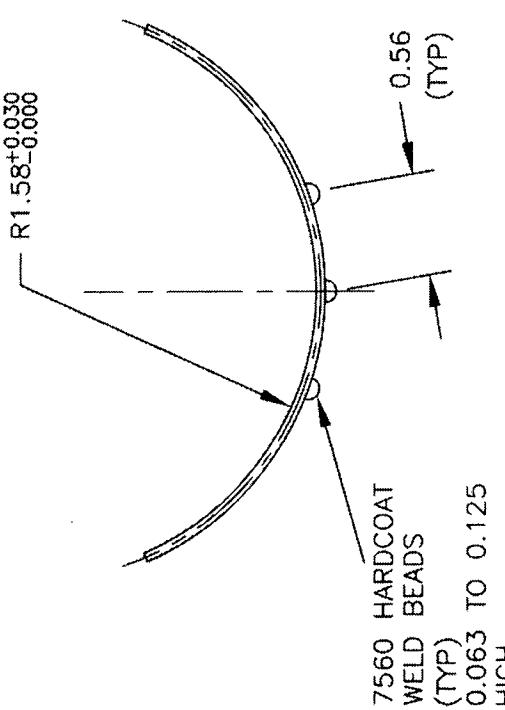


D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

**RELEASED**  
05-09-30**DETAIL J****DETAIL G****SECTION H-H  
(SCALE 1:1)****Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order:	30731
Description: WEARPLATE	Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      X Prototype

Measured by:	<i>W.M.</i>	Audited by:		Prototype Approval:	
Date:	07/02/14	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	